

Blue

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 10:25:48 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 41713		
Estimate Number	: 10833		
P.O. Number	:	Part Number	: D29331
This Issue	: 03/09/2008 S.O. No. :	Drawing Number	: D2933 REV C - BLUE
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 40281	Material	:
Written By	:	Due Date	: 26/09/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>3008.9.03</u>		
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: 1334872

ml 08/09/10

(3)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

ml 08/09/10

(3)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

ml 08/09/10

(3)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

ml 08/09/10

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 41713

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DJP 08/09/10 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. H 08/09/10

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME

-SPRAY PAINT DELFLEET BLUE

-CLEAR DELFLEET

B 126729

B 105918

B 105917

> ml 08 09 24 (3) (P10)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08.09.25

9.0

PACKAGING 1

PACKAGING RESOURCE #1.



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

8/9/05

(3X) 50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26 HJ


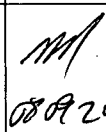
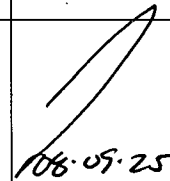
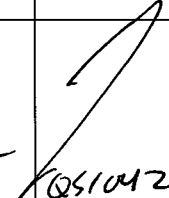
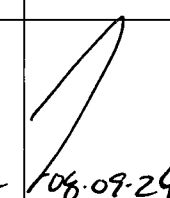
Job Completion



U 08/09.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2933-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/05/26
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41713</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-09-24	7.0	Primer is slightly visible on the edges of the saddle. R.c: Primer is slightly lighter than the base in color.	 Q51042	- Scuff: repaint per Q51005. - Next order grey primer will be used.	 08-09-24	 08-09-25	 Q51042	 08-09-24

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 41713	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

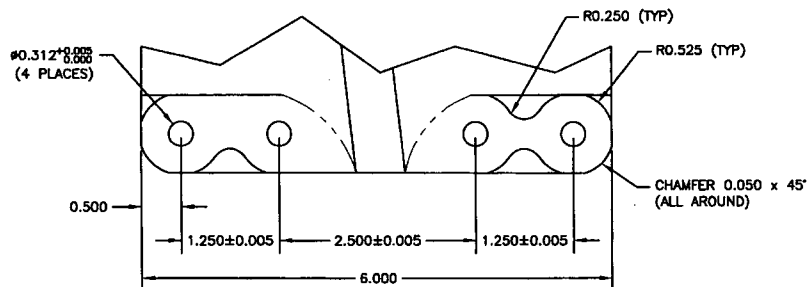
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.125	.124	.123		
B	0.100	0.140		.125	.124	.124		
C	0.100	0.140		.132	.128	.130		
D	0.210	0.230		.223	.222	.223		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577		
J	2.495	2.505		2.499	2.500	2.500		
K	0.257	0.262		.259	.259	.259		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.239	.239	.239		
N	0.100	0.140		.111	.111	.111		
O	0.540	0.560		.547	.549	.548		
P	0.490	0.510		.503	.504	.504		
Q	3.715	3.725		3.718	3.719	3.718		
R	2.470	2.510		2.490	2.491	2.490		
S	0.240	0.270		.257	.254	.253		
T	0.100	0.180		.138	.136	.138		
U	1.625	1.635		1.629	1.629	1.629		
V	1.362	1.372		1.366	1.367	1.367		
W	0.316	0.321		.320	.320	.320		
X	1.125	1.145		1.133	1.136	1.136		
Y	1.565	1.585		1.569	1.573	1.573		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: <i>cmk</i>	Date: 08/09/10
Audited by: <i>DJP</i>	Date: 08/09/10
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

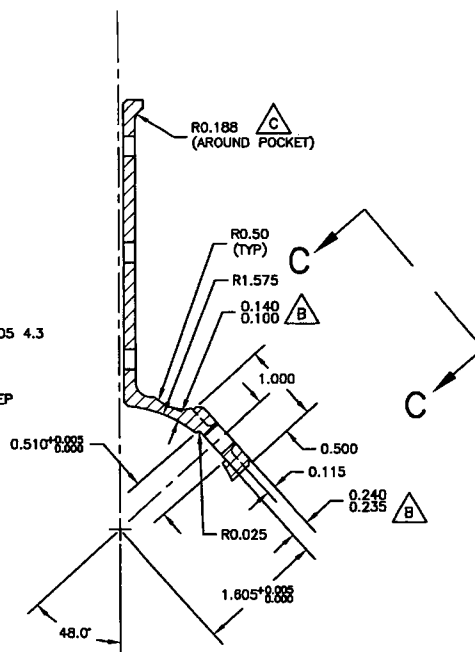


VIEW C-C

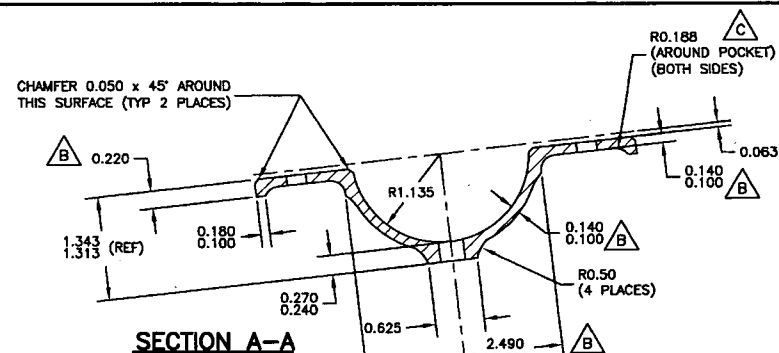
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

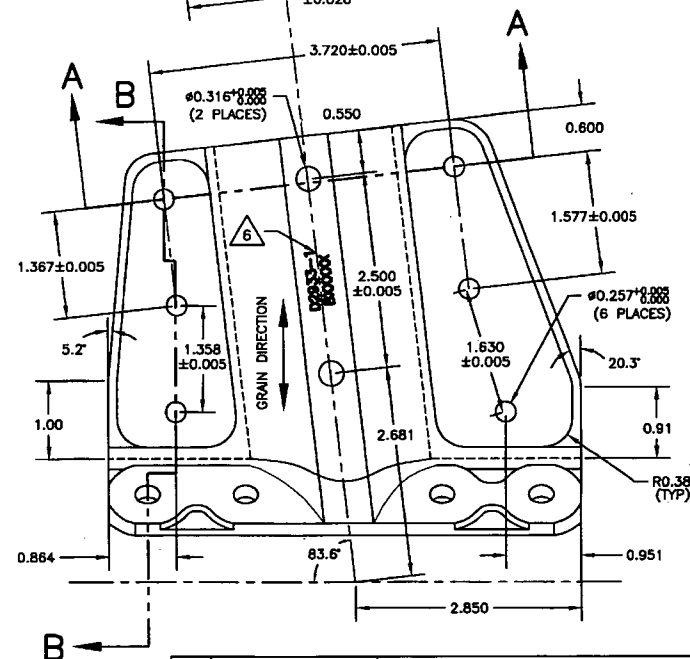
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07.02.12

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